

Y.I. TYPE

(15)

PROFILED DECKS

LITHGOWS 2TH

No 957-8-9

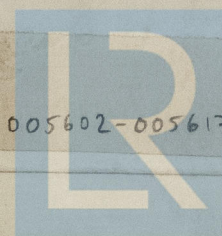
-60-61



n/n. "ACHED"

<u>Yard No.</u>	<u>Name</u>	<u>First Entry Rpt.No.</u>
957	"EMPIRE RIDLEY" EMPIRE RIDLEY	21638
958	"EMPIRE BAFFIN"	21587
959	"EMPIRE HOWARD"	21645
960	"EMPIRE RANGER"	21746
961	"EMPIRE ZEAL"	21769

DS 287



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005602-005617-0238

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LITHGOWS LTD

NO 957

YI TYPE

EMPIRE RIDLEY

MIDSHIP SECTION

AS BUILT

n/n "Acheo"

Greenock Report No 21638



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005602-005617-0239

SS. N° 957. S.S. "EMPIRE RIDLEY."

SECRET & CONFIDENTIAL

EMERGENCY PROGRAMME.

STEAM CARGO VESSEL "YI" TYPE.

MIDSHIP SECTION.

SCALE $\frac{1}{2}'' = 1'-0''$

TO CLASS 100A1 WITH FREEBOARD AT LLOYDS SPECIAL SURVEY.

DIMENSIONS:- 425'-0" B.P. ON L.W.L. x 56'-0" M-P-56'-3" EXT. x 27'-9" M-P TO 24'-0" DK 36'-10" M-P TO UPPER DK

LLOYDS NUMERALS

FIRST LONGITUDINAL NUMBER L x D = 425'0" x 36'75"	=	15193.75
SECOND LONGITUDINAL NUMBER L x (B x D) = 425'0" x (56'0" + 36'75")	=	39993.75
1/2 D TO UPPER DECK = 425'0" ÷ 26.83	=	11' 53"
D MOULDED DEPTH = 27'75" + 8'0"	=	35'75"
d = 27'75" - 3'7 1/4"	=	23'9"
d AT HALF LENGTH FORWARD	=	26'39"

EQUIPMENT NUMBER

SECOND LONGITUDINAL NUMBER = 425'0" x (56'0" + 36'75")	=	39418.75
1/2 D TO UPPER DECK = 425'0" ÷ 26.83	=	11' 53"
MIDSHIP ACCOMMODATION & CASING = 72'25" x 8'0" x 1/2"	=	289.00
SALOON ACCOMMODATION = 30'0" x 8'0" x 1/2"	=	120.00
EQUIPMENT NUMBER	=	39887.75

EQUIPMENT

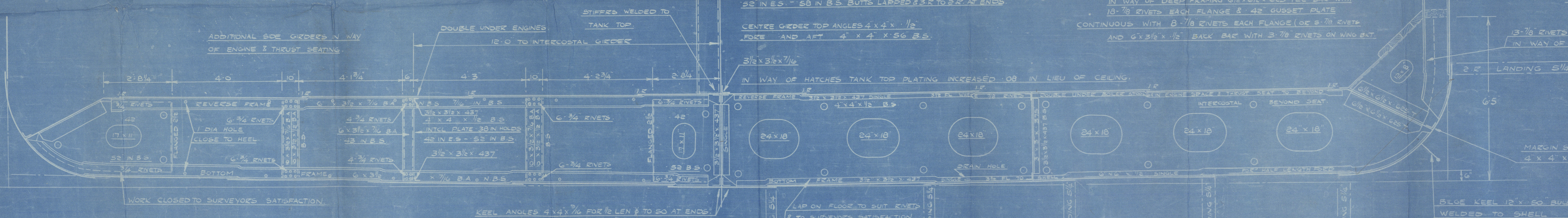
2 BOWER ANCHORS 68 CWT'S EACH STOCKLESS	
1 STEAM ANCHOR 19 CWT'S EX-STOCK	
325 FATHOMS 2 1/2" STUD CHAIN CABLE 600 CWT'S	
90 FATHOMS 1 1/2" STEAM CHAIN OR 5' FLEXIBLE STEEL WIRE 6 x 12	
180 FATHOMS 4 1/2" SPECIAL FLEXIBLE STEEL WIRE 6 x 24	
2 HAWSEYS 50 FATHOMS 8' HEMP OR 2 1/2" FLEXIBLE STEEL WIRE 6 x 12	
2 WARPS 90 FATHOMS 7' HEMP OR 2 1/2" FLEXIBLE STEEL WIRE 6 x 12	

RIVETING NOTE

RIVETS IN FRAMES TO FLOORS AND CROSS PLATES IN AFT PEAK SPACED 5 DIAM. APART CR TO CR.
RIVETS IN FRAMES TO SHELL AT FLAT OF DOUBLE BOTTOM FORD HALF LENGTH FORD SPACED 5 1/2 DIAM. (TWO COMPLETE ROWS)
RIVETS IN FRAMES TO FLOORS AT FLAT OF DOUBLE BOTTOM FORD HALF LENGTH FORD SPACED 5 1/2 DIAM. (TWO COMPLETE ROWS)
RIVETS IN SIDE FRAMES TO SHELL SPACED 6 1/2 DIAM. APART 5 1/2 DIAM. APART IN WAY OF FORE & AFT PEAK TANKS AND DEEP FRAMING FORD.
RIVETS IN BOTTOM FRAMES TO SHELL AFT HALF LENGTH FORD SPACED 7 DIAM. APART CR TO CR.
RIVETS IN 3/2 BUTTS OF OUTSIDE PLATING AND OF DECK STRINGER PLATES SPACED 3 1/2 DIAM. APART CR TO CR.
RIVETS IN 4/2 BUTTS OF OUTSIDE PLATING AND OF DECK STRINGER PLATES SPACED 4 DIAM. APART CR TO CR.
RIVETS IN SEAMS OF SHELL PLATING DECK PLATING AND INNER BOTTOM PLATING AS PER TABLE 40.
RIVETS IN BUTTS OF DECK PLATING INNER BOTTOM & MARGIN PLATING SPACED 4 DIAM. APART CR TO CR.
RIVETS IN BEAMS 1/2 BUTTS OF BULKHEAD AND TUNNEL PLATING MARGIN ANGLES AND WEATHER DECK STRINGER ANGLES AND BULKHEAD FRAME TO BULKHEAD SPACED 4 1/2 DIAM. APART CR TO CR.
RIVETS IN FLAT KEEL ANGLES. VERTICAL ANGLES CONNECTING FLOORS TO CENTRE GIRDER AND SHELL FLANGE OF WATERTIGHT BULKHEAD FRAME SPACED 5 DIAM. APART CR TO CR.
RIVETS IN FRAMES TO FLOORS AFT HALF LENGTH FORD REVERSE FRAMES TO FLOORS AND INNER BOTTOM PLATING. VERTICAL ANGLES TO FLOORS AND SIDE GIRDERS IN BULKHEAD STIFFENERS (EXCEPT PEAK BULKHEADS) AND IN DECK PLATING TO BEAMS ON EVERY FRAME SPACED 7 DIAM. APART CR TO CR.
RIVETS IN CENTRE GIRDER TOP ANGLES SPACED 7 DIAM. APART CR TO CR NON-WATERTIGHT.
RIVETS IN CENTRE GIRDER TOP ANGLES SPACED 5 DIAM. APART CR TO CR WATERTIGHT.

THE SCANTLING OF ANGLES BULB ANGLE AND CHANNEL SECTIONS GIVEN ON THIS PLAN ARE N.B.S. AND ARE IN ACCORDANCE WITH THE EMERGENCY PROGRAMME LIST.

STEM 10' x 2 1/2" STEENPOST 10' x 8" RUDDER POST 10' x 8"



SPECIAL PLAN OF BOTTOM STRENGTHENING FORWARDED TO BE SUBMITTED LATER

DISPOSITION OF FLOORS

SOLID FLOORS ON EVERY FRAME IN ENGINE SPACE AND FOR 3/4 LENGTH FORD UNDER BULKHEAD BEARERS & BULKHEADS PARTIAL SOLID UNDER THRUST ELSEWHERE SOLID FLOORS ON EVERY THIRD FRAME BRACKET FLOOR INTERMEDIATE

KEEL OUT.

52' x 78' FOR 1/2 LEN & TO 68' AT ENDS BUTTS LAPPED 2 1/2 TO 3 1/2 AT ENDS 1 RIVETS IN BUTTS OVER 72

"A" IN.

78' x 63' FOR 1/2 LEN & TO 50' AT ENDS BUTTS LAPPED 2 1/2 TO 3 1/2

"B" OUT.

70' x 63' FOR 1/2 LEN & TO 50' AT ENDS BUTTS LAPPED 2 1/2 TO 3 1/2

"C" CLINKER

63' x 63' FOR 1/2 LEN & TO 50' AT ENDS BUTTS LAPPED 2 1/2 TO 3 1/2

"D" IN.

63' x 63' FOR 1/2 LEN & TO 50' AT ENDS BUTTS LAPPED 2 1/2 TO 3 1/2

MARGIN PLATE TO RULE 39 FITTED ABOUT 44' x 54' - 60 IN B.S. BUTTS LAPPED 2 1/2 THROUGHOUT.

LITHGOW'S LTD

Y TYPE

FITTED ON NOS 957-9 ONLY.

BUILT
WELDED
STERN FRAME

LLOYD'S APP.

14.5.40

NO 957. n/n "Vicheo"
EMPIRE RIDLEY^{ex} *

Greenock Report No. 21638

NO 959

EMPIRE HOWARD

Greenock Report No. 21645



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SECTION OF BOSS AT 7-12
FORWARD OF AFT PERP
LOOKING FORWARD

Also 969-70-1-2-78-9-80-1-2-90

Y1 + Y2 Type

(8)

LITHGOWS LTD Nos.

957/8/9/60/1/2/3/4/5.

DS. 284

RUDDER

n/n "ACHEO"

<u>Yard No.</u>	<u>Name</u>	<u>First Entry Rpt. No.</u>
957	"EMPIRE RIDLEY"	21638
958	"EMPIRE BAFFIN"	21587
959	"EMPIRE HOWARD"	21645
960	"EMPIRE RANGER"	21746
961	"EMPIRE ZEAL"	21769
962	"EMPIRE SPARTAN"	21797
963	"EMPIRE CONRAD"	21846
964	"EMPIRE PRAIRIE"	21702
965	"EMPIRE ADDISON"	21770

<u>Yard No.</u>	<u>Name</u>	<u>First Entry Rpt. No.</u>
969	"EMPIRE AUSTEN"	21837
970	"EMPIRE GALAHAD"	21915
971	"EMPIRE LANCER"	22086
972	"EMPIRE PENNANT"	22115
973	"COOLGORN"	22116
976	"CAPE HOWE"	22190
977	"EMPIRE TREASURE"	22243
978	"EMPIRE BEATRICE"	22284
979	"EMPIRE BUCKLER"	21969
980	"EMPIRE PIBROCH"	22047
981	"EMPIRE FALSTAFF"	22342
982	"EMPIRE SERVICE"	22374
990	"EMPIRE FLORIZEL"	22357.



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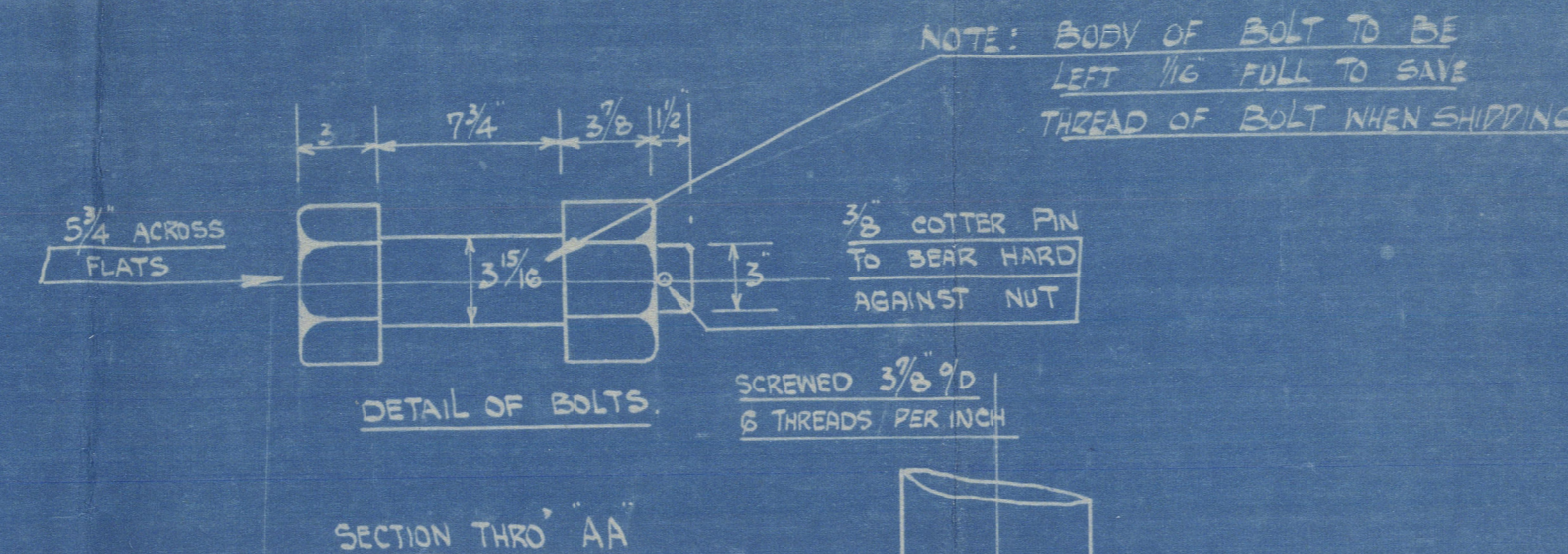
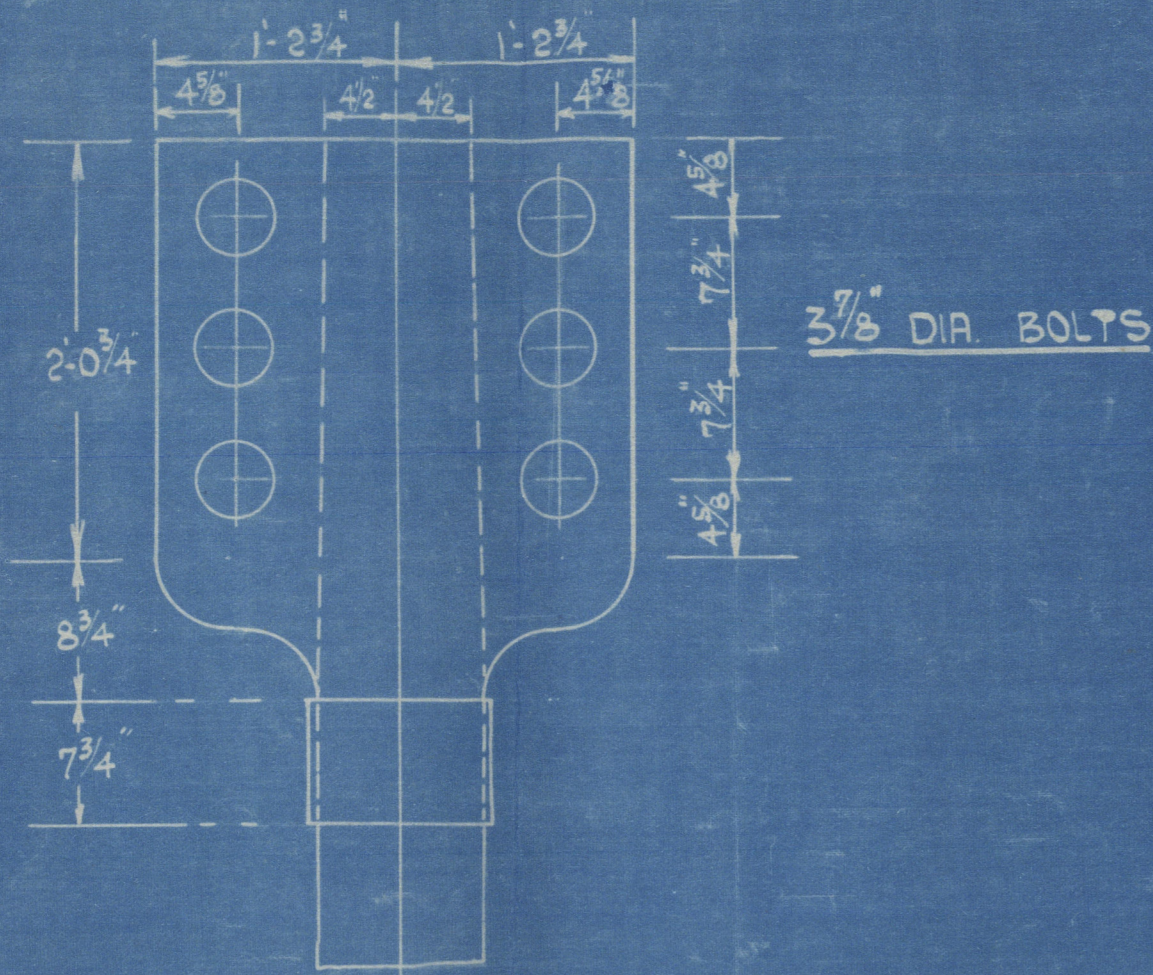
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Y1 & Y2 TYPES. STREAMLINE RUDDER.

S.S. Nos 957-8-9-60-1-2-3-4 & 5.

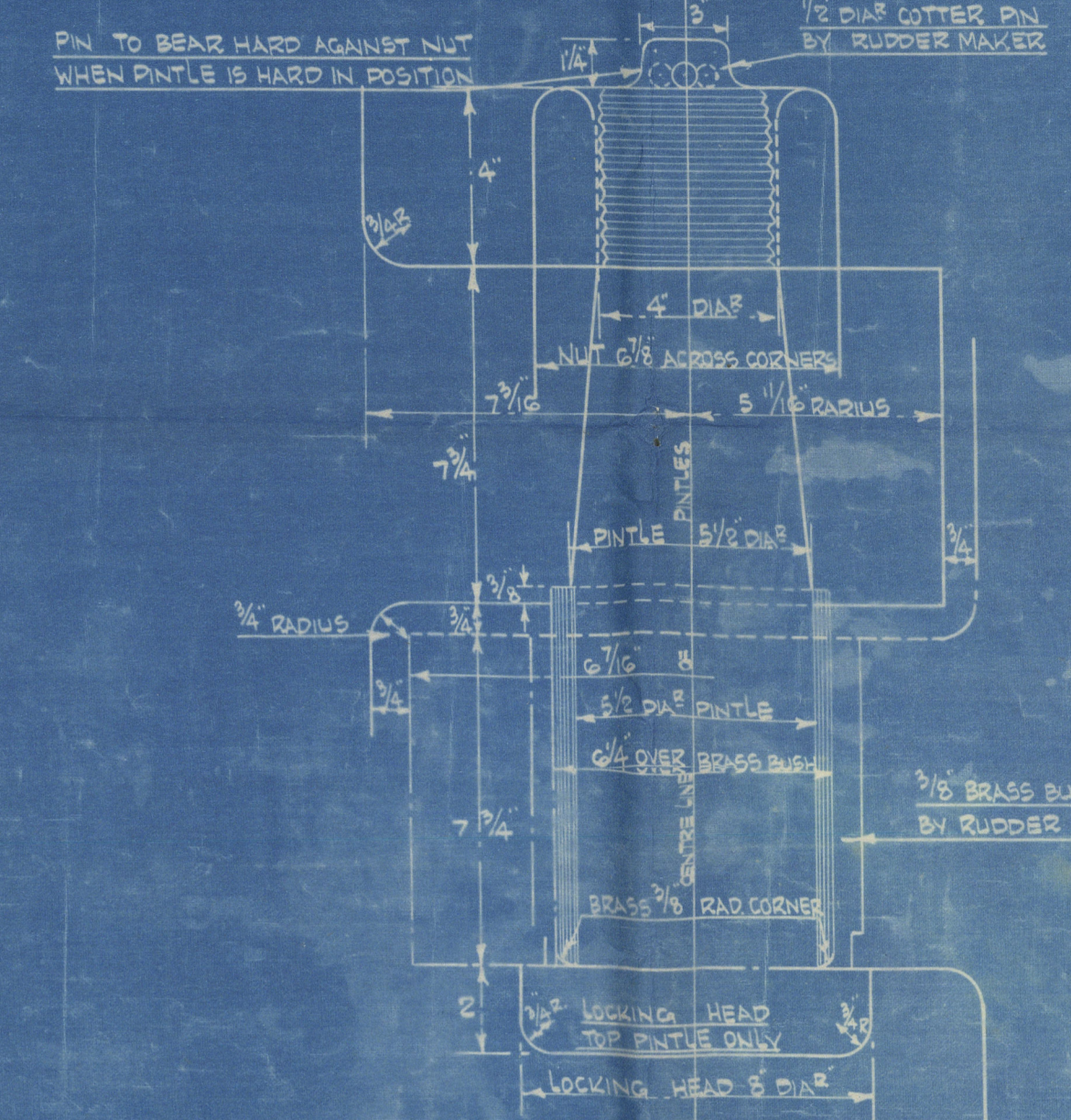
SCALE 1" = 1 FOOT
DETAILS AS INDICATED

NO. 3022 SIMILAR BUT FITTED WITH HORIZONTAL
RUDDER STOCK "BEST QUALITY FORGING."
SEE DETAIL FOR AN F.M. DETAILS
RUDDER FRAME - BEST QUALITY STEEL CASTING.

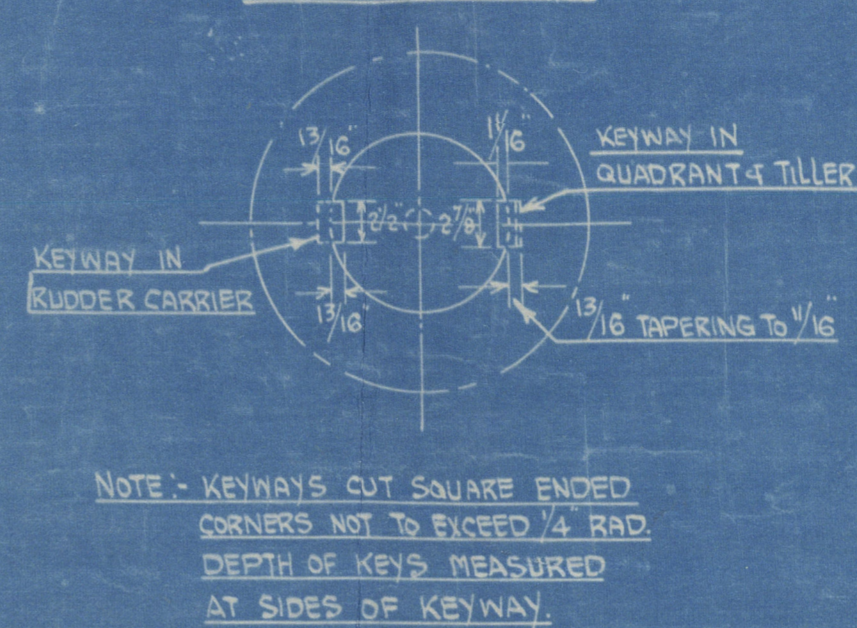


REMARKS: 452'0" D.P. & 50'0" W.P. TO SECOND DECK - 30'0" W.P. TO UPPER DECK.
TO CLASH 100' A.I. WITH FOREBOARD AT LLOYD'S SPECIAL SURVEY.
LLOYD'S REG. NO. 4. ACTUAL SHIP SPEED 10 1/2 KNOTS. (LLOYD'S MIN. SPEED FOR RUDDER - 12 KNOTS)
TOTAL IMMERSED AREA OF RUDDER FROM FORE SIDE OR POST 151 SQ. FT.
CENTRE OF GRAVITY OF AREA FROM CENTRE LINE OF PINTLES - 4'3 1/2" FEET
AREA = 57'0" DIAM. OF RUDDER STOCK - 18' DIAM.
KEYWAYS ETC. TO BE CUT IN RUDDER STOCK TO PARTICULARS GIVEN.
RUDDER STOCK TO BE ACCURATELY TURNED TO DIMENSIONS GIVEN.
RUDDER FRAME TO BE ACCURATELY CAST TO SHAPE AS PER DETAILS.
RIVET HOLES TO BE BORED PLUMB THRU FRAME, SIZE MUST NOT BE LESS THAN GIVEN.
RUDDER NOT TO EXCEED GIVEN SCANTLING'S. EXCESS OVER B.T. WEIGHT WILL NOT BE PAID.
PATTERN OF RUDDER FRAME TO BE APPROVED BY SHIPBUILDERS' DESIGNER BEFORE CASTING.

NOTE: ALL PINTLES TO BE SUPPLIED COMPLETE
BY RUDDER MAKERS. PINTLES TO BE OF STEEL
MADE & EFFICIENTLY FITTED AS PER DETAILS.
BRASS BUSHES MUST BE TURNED IN ONE PIECE
AND PROPERLY SHOWN ON PINTLES.



DETAIL OF KEYWAYS



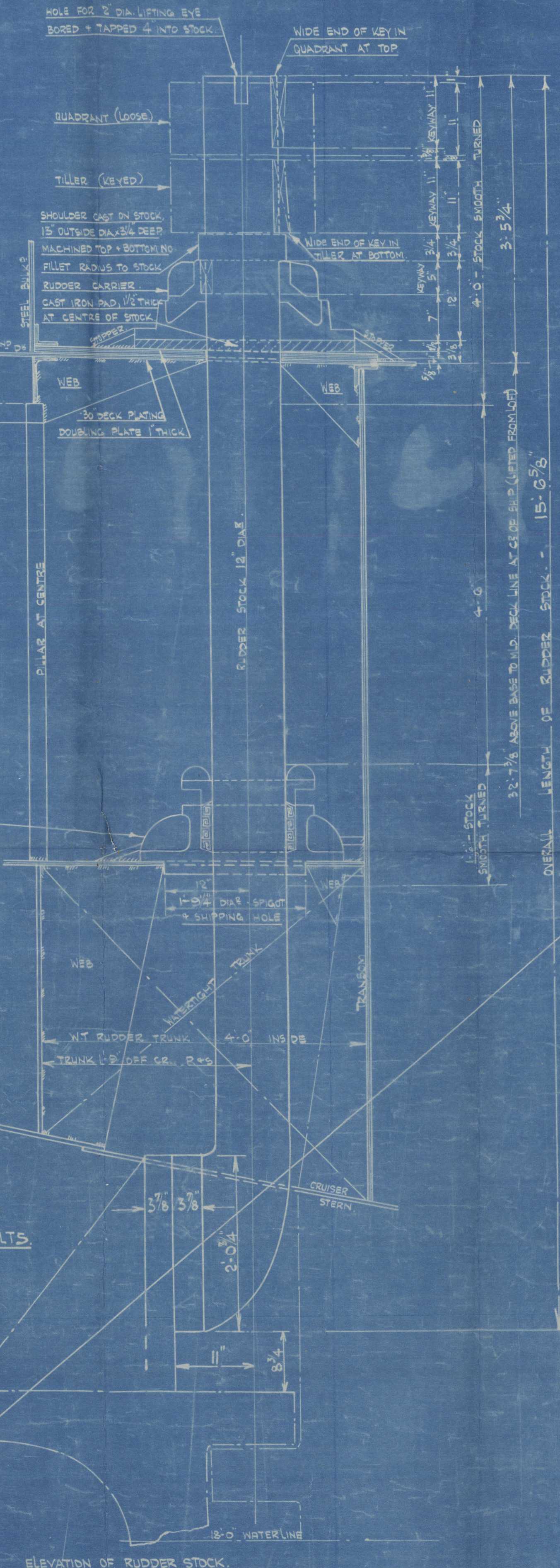
NOTE: KEYWAYS CUT SQUARE ENDED
CORNERS NOT TO EXCEED 1/4 RAD.
DEPTH OF KEYWAYS MEASURED
AT SIDES OF KEYWAY.

HEIGHT OF DECK ABOVE BASE LINE OF SHIP - 32' 7 1/2"
HEIGHT OF RUDDER STOCK ABOVE DECK - 3' 5 1/2"
TOTAL LENGTH OF RUDDER ABOVE BASE LINE - 36' 1 1/2"
HEIGHT TO BOTTOM OF RUDDER STOCK - 20' 6 1/2"
TOTAL LENGTH OF RUDDER STOCK - 15' 6 1/2"

WT. CAST IRON STUFFING BOX
WITH PATTERN NO. 307
WELDED TO SHIP TO SUIT
SHIPPING HOLE (12 1/2" DIA.)
SOLE FITTED STEEL TO STEEL
EIGHT FITTED TO TOP PLATE ALL ROUND

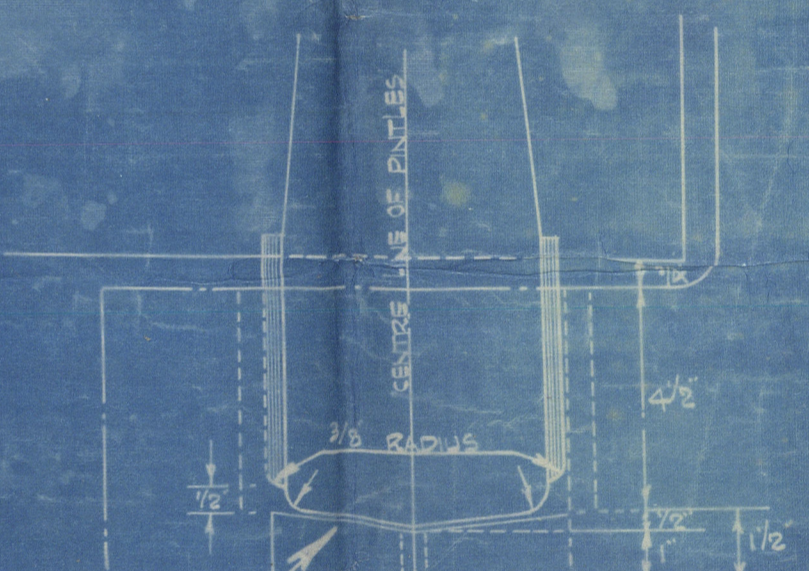


NOTE: WHEN FLOATING RUDDER
SLIGHT CLEARANCE TO BE LEFT
BETWEEN BOTTOM OF BOTTOM PINTLES &
BEARING DIAL TO ENSURE THAT CARRIER
IS BEARING ENTIRE WEIGHT OF RUDDER.



DETAIL OF ALL RUDDER GUDGEONS & PINTLES (EXCEPT BOTTOM GUDGEON)

SCALE 1/4" FULL SIZE



DETAIL OF BOTTOM GUDGEON & BEARING PINTLE

SCALE 1/4" FULL SIZE

DETAILS NOT INDICATED SIMILAR TO SKETCH ABOVE

CONSTRUCTION NOTE - RUDDER FRAME TO BE BUILT ON TOP
OF BOTTOM PLATE. ALL INTERSURFACES OF RUDDER TO BE
COATED WITH ANTI-RUST SOLUTION. COCK MATHES TO BE
PAINTED IN THE ROSE COLOUR. TO TOP PLATE LEVEL
TOP PLATE LAND IN POSITION. ENTIRE RUDDER FINISHED COMPLETE
& BEAMS SAWED BETWEEN SOLUTION. PULSED INTO EACH
COMPARTMENT WITH FULL CLOSING DISCS. WELDED INTO
FILLING HOLES & FILLET WELD ROUND LIFTING EYE. WRAPPER
PLATES FITTED IN POSITION & WELDED AS INDICATED

APPROVED
LLOYD'S REGISTER OF SHIPPING
James H. Clark
DATE 2/12/100